

Work Order ID 112124

112124

Page 1

January-29-14 3:13:38 PM

Item ID: D206-642-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

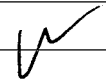
Start Date: 1/29/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/14/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2650	Rev F(DEO)								

100 Document Control - *VERIFY USB or PAPERWORK* 0.00

100

DC

DOCUMENT CONTROL

Memo

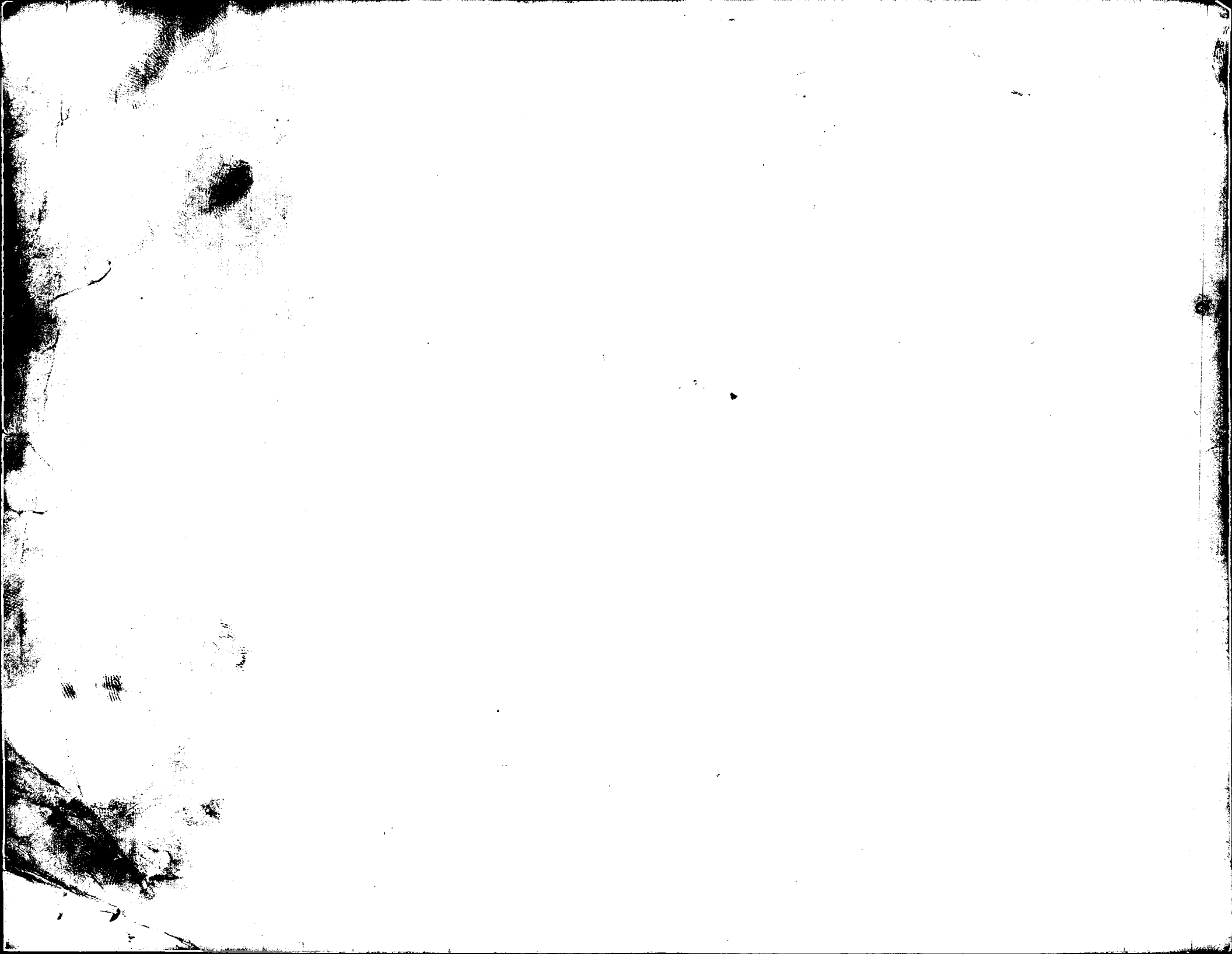
0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-241

CHG006

N/A MJS 14-02-25



Work Order ID 112124

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Item ID: D206-642-241

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Stop

NS2

Start Date: 1/29/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M122324/M127069

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

- DC 14/01/30

BE 14-01-30

- DC 14/01/30



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Item ID: D206-642-241 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube, High Gear(Fits LH or RH)
 Start Date: 1/29/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/14/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

16-Open crossbolt holes to Ø0.3125" *N/A*

17-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

18-ream crossbolt spacer holes to finished size as per Dwg D2650, D2650-3
 Drilling Detail ***DO NOT OPEN X-BOLT SPACER HOLE OF DETAIL B***

19-Deburr tube as per QSI 018 and blow out chips from inside the tube

- DC 14/01/30

- DC 14/01/31

Signature
 Report to Sub

Work Order ID 112124

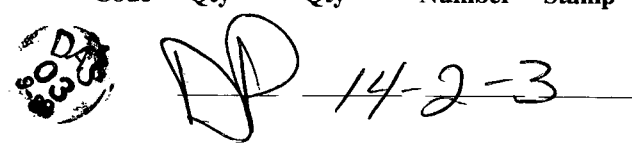
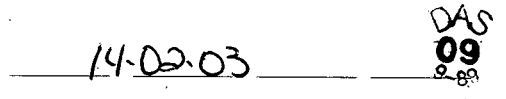
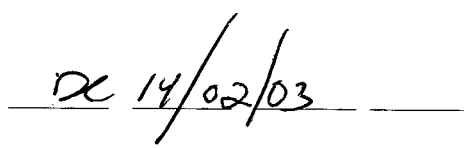
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Item ID: D206-642-241 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear(Fits LH or RH)
 Start Date: 1/29/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

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Item ID: D206-642-241

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Stop ***NS2***Start Date: 1/29/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC7-Inspect Chemical Conversion Coat

0.00


150

QC

Memo

0.00

Quality Control

 14-2-3

160

Skidtubes

0.00

160

Skidtubes

Memo

0.00

Skidtubes

1- Open and c/sink one crossbolt spacer holes as per Dwg D2650 (DEO Detail B)(without cutting fluid)

2-Deburr and blow out all chips from inside the tube

OK 14/02/03

Work Order ID 112124

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Item ID: D206-642-241 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear(Fits LH or RH)
 Start Date: 1/29/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject # Number	Insp. Stamp
180 *180* Skidtubes	Skidtubes	0.00							
	Memo	0.00							
	1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required								
	2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting								
	Start Date: <u>1/29/14</u> Time: <u>11:20</u>								
	Finish Date: _____ Time: _____								
	Pick:								
	Qty Part NumberDescriptionBatch								
	A/RSikaflex-291 <u>127918</u>								
	Sikaflex expire date: <u>12/08/16</u>								
190 *190* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

DL 14/02/03

14-2-4

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Item ID: D206-642-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Stop ***NS2***Start Date: 1/29/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Remove alodine in one area per DEO detail B from around hole and prepare for welding

2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M122324

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

5- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

6- Install D2680-041 Nut Plate as per Dwg D2650

BE14-02-05

- DC 14/02/09

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Item ID: D206-642-241

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 1/29/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
220									DAS
QC	Memo	0.00							9
Quality Control									9-89
230	QC5- Inspect part completeness to step on W/O	0.00							
230									DAS
QC	Memo	0.00							9
Quality Control									9-89
240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								

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 Start Date: 1/29/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/14/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3 Alum	0.00							
250	<i>M126 829..</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>7:10</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>7:40</i>								
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									

DAS 34 9:38

1x 6 11 140212

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Item ID: D206-642-241 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
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 Start Date: 1/29/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/14/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

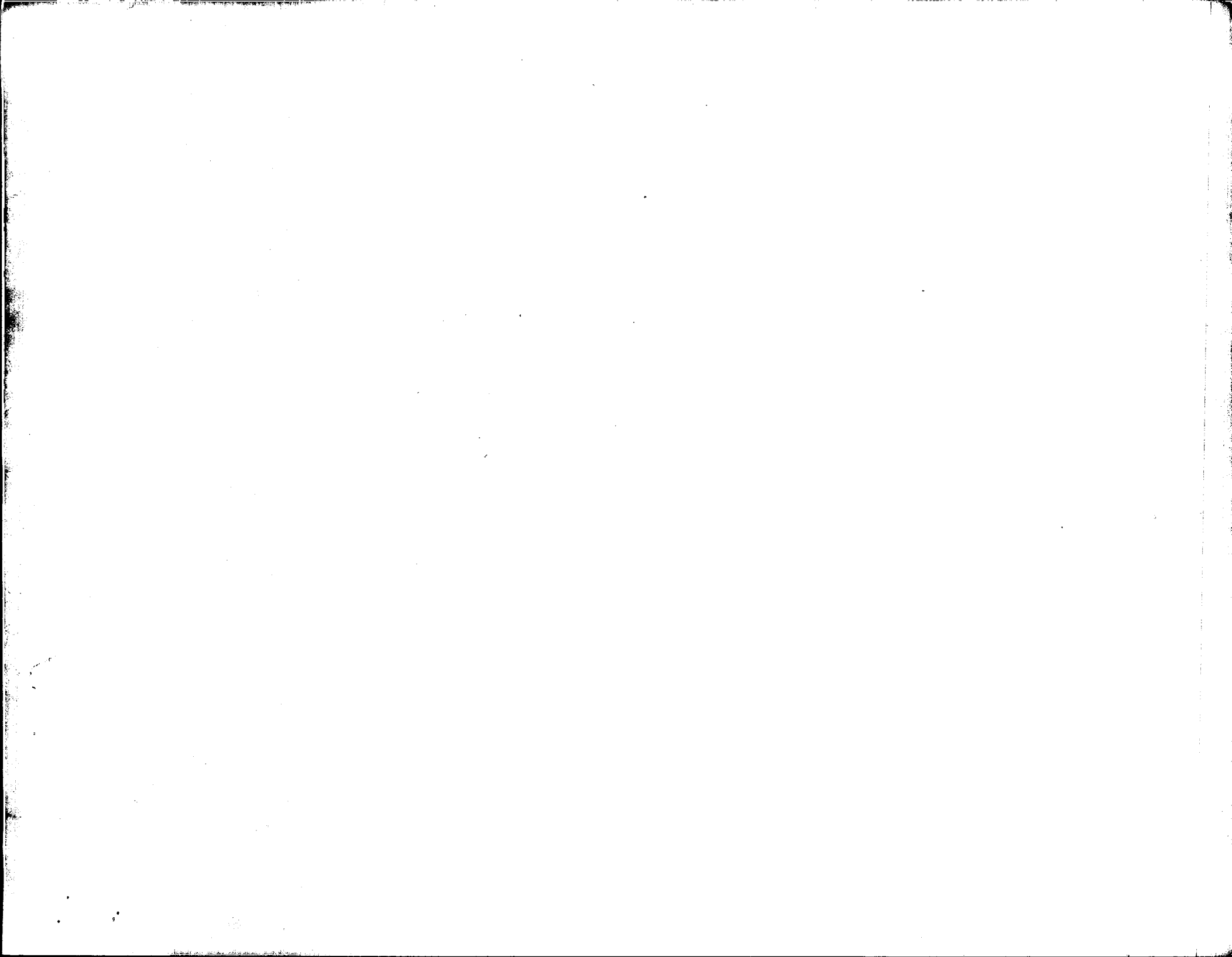
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinishing	0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>111127918</u> Sikaflex expire date: <u>14109</u> 2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive. 3-Install MS27039-4-06 Screw as per DEO 9153. 4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>111127918</u> Sikaflex expire date: <u>14109</u> 5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4 A/R Batch: <u>11128102</u>								
300	QC5- Inspct part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

14/2/20

1



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Item ID: D206-642-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 1/29/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	Packaging	0.00							
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-241								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

14-2-25
DAS
6
9-89

ML5 14-02-25

H 14-02-25

Picklist Print

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Work Order ID: 112124

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 1/29/14

Required Date: 2/14/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: 04.12.02 Revised procedural stepsKJ/JLM IPP RevP: revise and update route/bom
DD 10.01.06 verf:ECIPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD IPP Rev:R
12.11.22 now swage per ecn12-679 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 Skidtube, 206 Skidtube		Manufactured	No			110	Each	20.0000	1			12/14/01/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		20							
				110799		20							
D4720-1 Spacer		Manufactured	No			200	Each	185.0000	17			12/14/02/04	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		185							
				103902		185							
D3286-1 Doubler		Manufactured	No			110	Each	89.0000	2			12/14/01/30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		89							
				90503		4							
				91158		85							
D2647 Cap		Manufactured	No			110	Each	11.0000	1	1		12/14/01-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		11							
				102371		1							
				107588		10							
D2654-3 Web		Manufactured	No			180	Each	6.0000	1			12/14/02/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002		6							
				105172		1							
				109991		4							
				110450		1							

Picklist Print

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Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 1/29/14

Required Date: 2/14/14

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

548.0000

52

Cherry Rivet

DL 19/02/03

Location

Loc Qty

Loc Code

ST327

98

123265

98

st552

450

m126534

10

m126691

440

D2649

Manufactured

No

200

Each

351.0000

1

1

Cross Bolt Spacer

BE 14/02/05

Location

Loc Qty

Loc Code

LG001

351

107906

169

108633

176

90497

6

D3286-3

Manufactured

No

200

Each

123.0000

2

2

Spacer

BE 14/02/05

Location

Loc Qty

Loc Code

LG001

123

109097

61

91160

62

D2680-041

Manufactured

No

Each

4.0000

Nut Plate

DL 14/02/04

Location

Loc Qty

Loc Code

ST014

4

108819

4

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Start Date: 1/29/14 Required Date: 2/14/14
 Start Qty: 1.00 Required Qty: 1.00

CR3212-4-03 Purchased No Each 1,183.0000
 Cherry Rivet

OK 14/22/04

Location	Loc Qty	Loc Code
ST327	1083	
114889	1	
119017	700	
m123265	382	
st552	100	
m114859	100	

CCR264SS3-3 Purchased No Each 302.0000
 Cherry Rivet

OK 14/22/04

Location	Loc Qty	Loc Code
ST327	302	
m126282	132	
m126333	170	

D2646 Manufactured No 270 Each 23.0000
 Aft Cap

1 14/02/12

Location	Loc Qty	Loc Code
FG	4	
85848	2	
90495	2	
FP001	19	
103306	18	
107857	1	

B110816

D2651-1 Manufactured No 270 Each 168.0000
 Plug

18 14/02/12

Location	Loc Qty	Loc Code
FP001	168	
103305	30	
104843	3	
106456	135	

B111875

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Shop Packet Print

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Required Date: 2/14/14

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

270

Each

6,599.0000

1

1

14/02/12

WASHER

Location

Loc Qty

Loc Code

ST294

2199

M127693

2199

X1

ST510a

4400

M127813

1400

M127904

3000

D2651-3

Manufactured

No

270

Each

396.0000

18

18

14/02/12

O-Ring

Location

Loc Qty

Loc Code

FP001

396

104725

136

108583

160

110659

100

X13

MS27039-1-08

Purchased

No

270

Each

1,053.0000

46

46

14/02/12

Screw

Location

Loc Qty

Loc Code

GA

51

m125654

51

st507

1002

m126319

2

m127255

500

m127813

500

X16

ALS4-1032-130

Purchased

No

270

Each

1,757.0000

44

44

14/02/12

Rivnut 123683-1

Location

Loc Qty

Loc Code

st510

1757

M126109

1757

OK OK OK
14/02/12

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Shop Packet Print

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Picklist Print

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Work Order ID: 112124

Parent Item: D206-642-241

Start Date: 1/29/14

Required Date: 2/14/14

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

270

Each

85.0000

1

1

Screw

Location

Loc Qty

Loc Code

ST306

85

m126534

85

NAS1149D0332J

Purchased

No

270

Each

1,848.0000

46

46

Washer

Location

Loc Qty

Loc Code

ST293

387

m127431

387

ST294

28

m125807

28

ST510a

1433

m127374

9

m127389

824

m127916

600

D3537-1

Manufactured

No

270

Each

21.0000

4

4

Wearpad

Location

Loc Qty

Loc Code

FG

18

B110821

79833

8

88562

10

FP001

3

110341

3

D3537-3

Manufactured

No

270

Each

21.0000

1

1

Wearpad

Location

Loc Qty

Loc Code

FG

8

B111825

86237

8

FP002

13

103014

13

January-29-14 3:13:37 PM

Shop Packet Print

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Picklist Print

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Page 6

Work Order ID: 112124

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 1/29/14

Required Date: 2/14/14

Start Qty: 1.00

Required Qty: 1.00

D3535-13 Manufactured No 270 Each 8.0000 1 1 1/10/2/12
Stainless Steel Wearplate Fwd

Location	Loc Qty	Loc Code
FG	2	
86229	2	
FP002	6	
110348	6	

D3536-13 Manufactured No 270 Each 15.0000 1 1 1/10/2/12
Gasket Fwd

Location	Loc Qty	Loc Code
FG	6	
81344	2	
89686	4	
FP001	9	
110777	9	

D3535-21 Manufactured No 270 Each 5.0000 1 1 1/10/2/12
Stainless Steel Wearplate Center Fwd

Location	Loc Qty	Loc Code
FP001	5	
102342	5	

D3536-21 Manufactured No 270 Each 7.0000 1 1 1/10/2/12
Gasket Center

Location	Loc Qty	Loc Code
FP001	7	
104203	7	

D3535-33 Manufactured No 270 Each 9.0000 1 1 1/10/2/12
Stainless Steel Wearplate Aft

Location	Loc Qty	Loc Code
FP002	9	
110205	9	

January-29-14 3:13:37 PM

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Page 6

Picklist Print

January-29-14 3:13:37 PM

Page 7

Work Order ID: 112124

Parent Item: D206-642-241

Start Date: 1/29/14

Required Date: 2/14/14

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

D3536-33

Manufactured No

270 Each 13.0000

1 44 1 10/02/12

Gasket Aft

Location

Loc Qty

Loc Code

FP001

13

101835

3

110836

10

X

January-29-14 3:13:37 PM

Shop Packet Print

Page 7

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

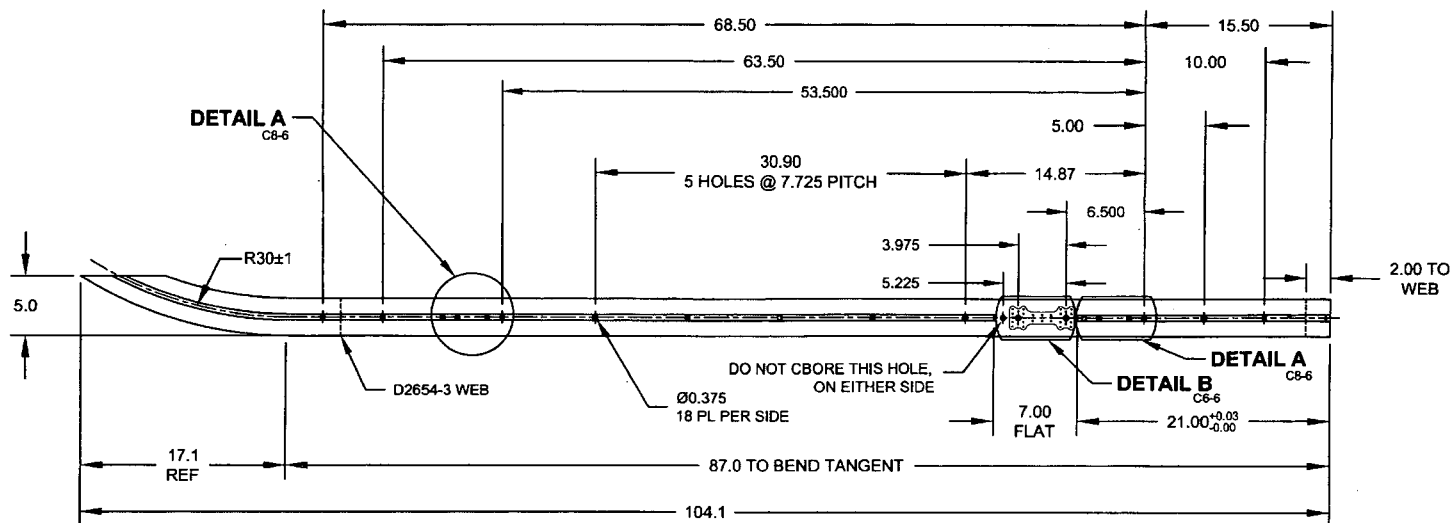
112124 MLC
1401-29

DEO ATTACHED
RELEASED
08.07.23/17

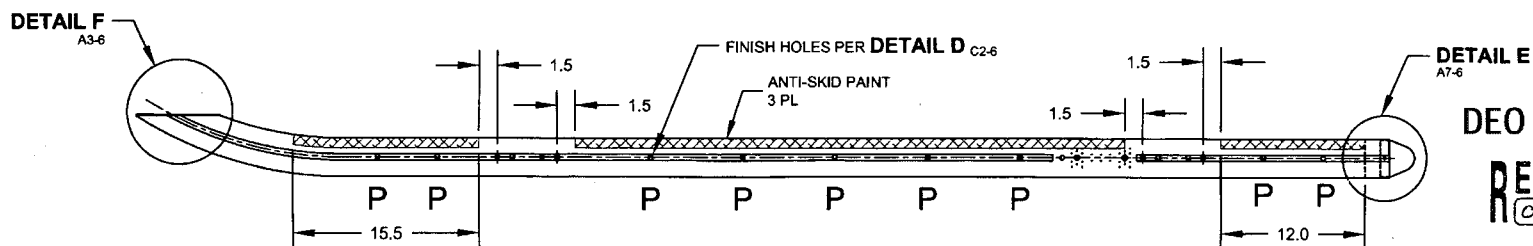
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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D2650-3 BENDING/DRILLING DETAIL



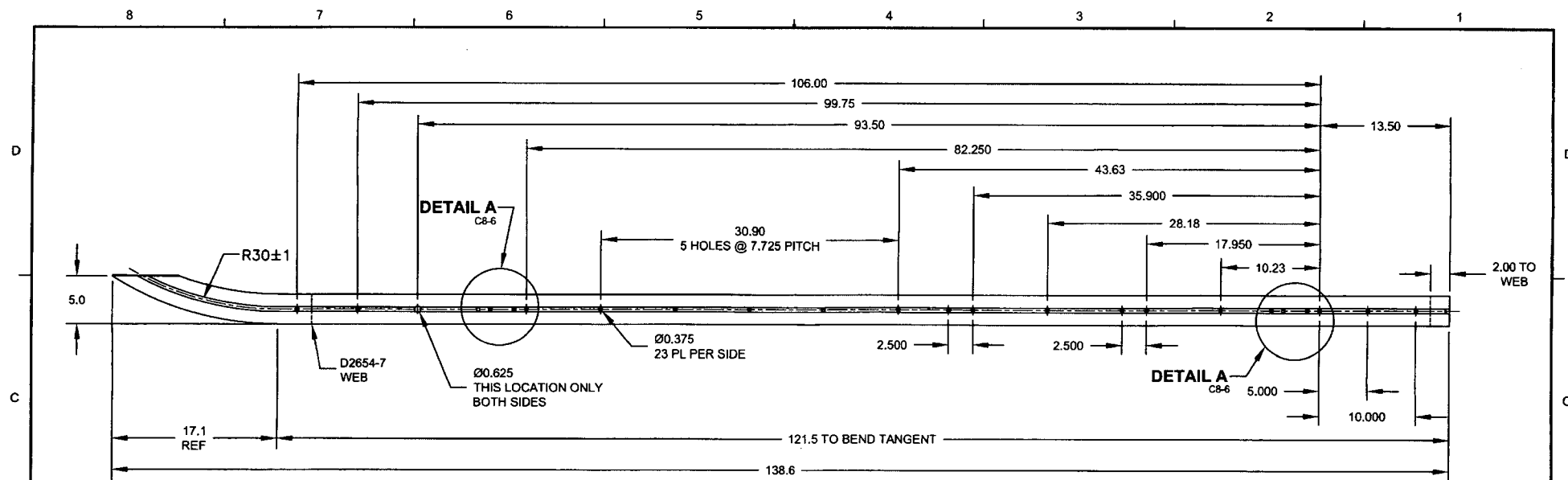
D2650-3 ASSEMBLY/FINISHING DETAIL

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05 07 22 118

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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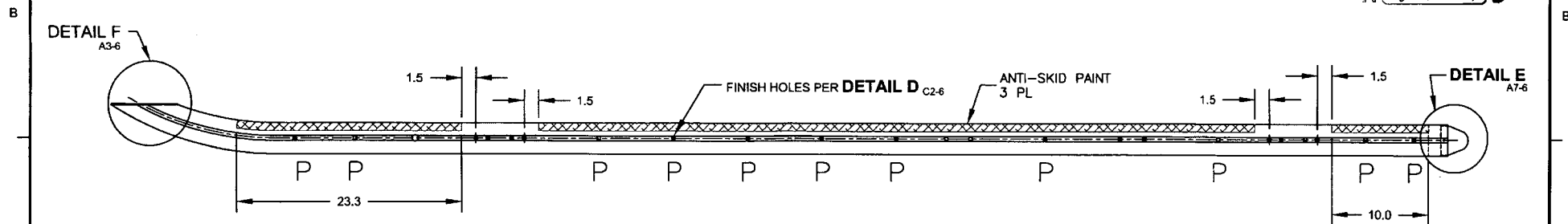
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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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D2650-7 BENDING/DRILL DETAIL

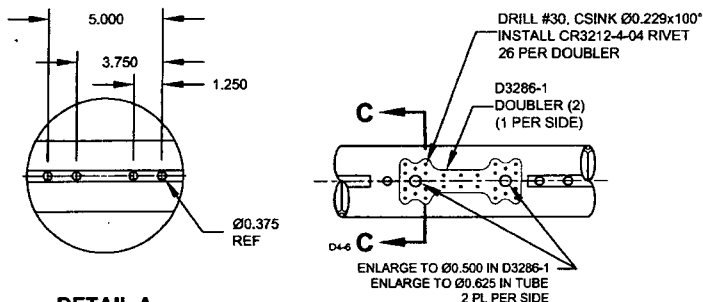
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RELEASED
08 07 22



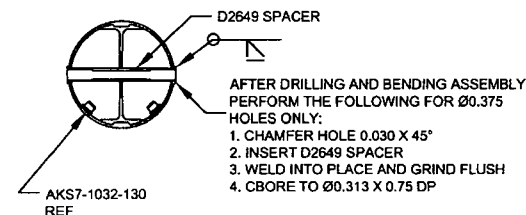
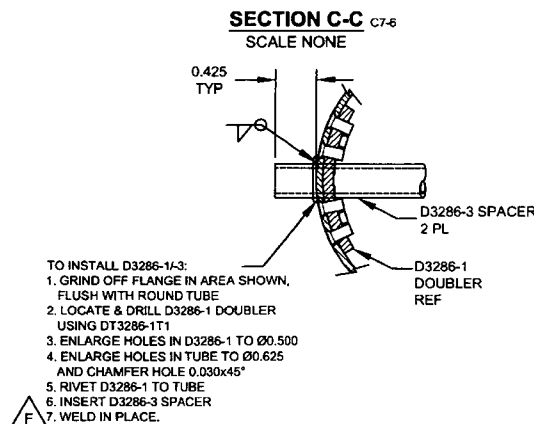
D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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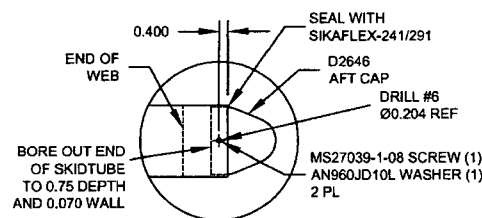


DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-5

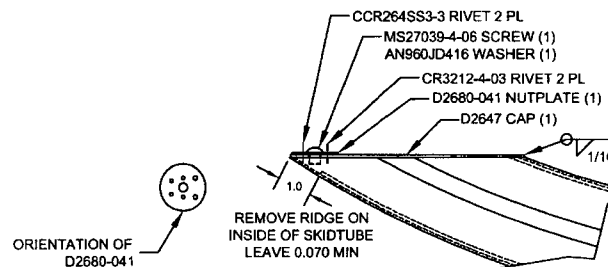
DETAIL B
SCALE 2X
C3-2
C3-3



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-22-13

DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

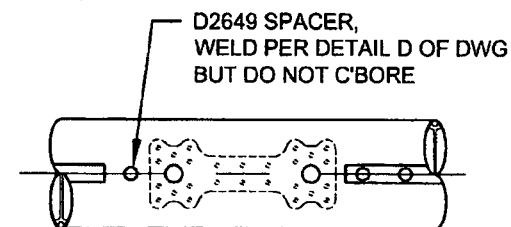
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

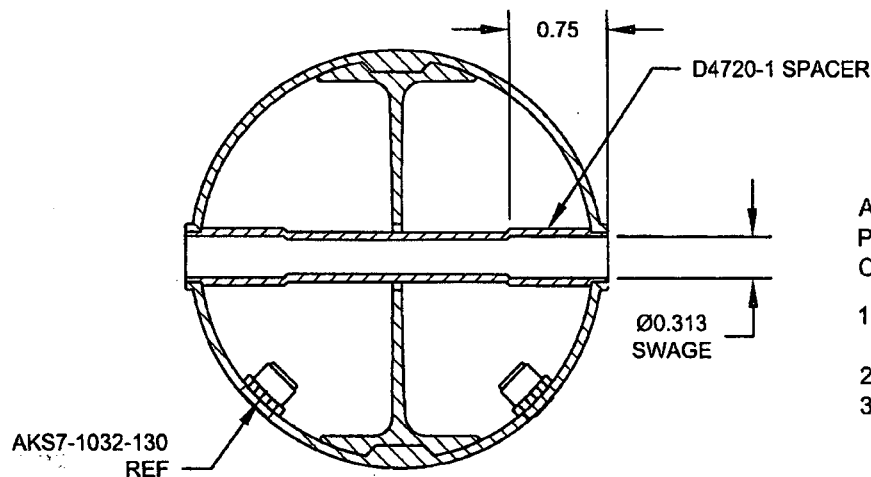
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

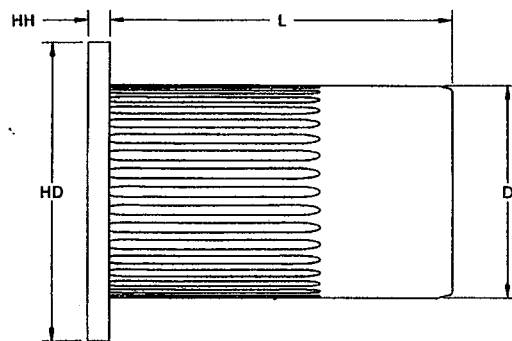
FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

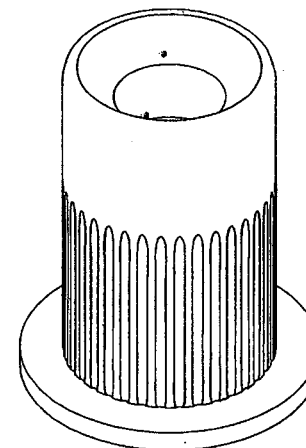
1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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SPECIFICATION CONTROL DRAWING



D3683-X INSERT



DART P/N	THREAD SIZE	"D" MAX	"HD" ±0.015	"HH"	"L" ±0.015	POSSIBLE SUPPLIERS
D3683-1	#10-32	Ø0.296	Ø0.415	0.030	0.475	AVIBANK MFG INC P/N: ALS7-1032-130 ALS4-1032-130 AKS7-1032-130 AKS4-1032-130 ATLAS ENGINEERING: AELS-1032-130 SPAENAU INC: 215-074
D3683-3	1/4-28	Ø0.390	Ø0.500	0.030	0.580	AVIBANK MFG INC P/N: ALS7-428-185 ALS4-428-185 AKS7-428-185 AKS4-428-185 ATLAS ENGINEERING: AELS-428-185 SPAENAU INC: 215-076

NOTES:

- MATERIAL: C-1010 OR C-1008 STEEL
- FINISH: CAD PLATED PER QQ-P-416 TYPE II (GOLD) CLASS 2 WITH CLEAR PROTECTIVE COATING OR ZINC YELLOW PLATED PER ASTM-B633, FE/ZN 8, TYPE II WITH CLEAR PROTECTIVE COATING (OPTIONAL)
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: NONE
- WEIGHT: N/A
- THREADS: UNIFIED, CLASS 2B PER ASME B1.1
- A CERTIFICATE OF CONFORMITY IS REQUIRED FROM THE MANUFACTURER TO VERIFY MATERIAL, FINISH, AND THREADS ARE PER THIS DWG

RELEASED
07.11.21

B	ADDED P/N D3683-3	RF	09.03.30
A	NEW ISSUE	DC	07.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DZ	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3683	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		INSERT	NTS
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